

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Work Order ID 136894

Wednesday, September 16, 2015 3:20:39 PM

136894

Page 2

Item ID: DSI 9268-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Basket Volume Increase Modification

Stop

NS2

Start Date: 9/16/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/02/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI 9268-011

Location: _____

PPP rev: _____

OCT 08 2015

DAS
6
389

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

OCT 08 2015

MLJ OCT 08 2015

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Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 136894

136894

Parent Item: DSI 9268-011

DSI 9268-011

Parent Item Name: Basket Volume Increase Modification

Start Date: 9/16/15

Required Date: 10/02/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC IPP
REV:E 15.03.26 AS PER DSI REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-21A *AN4-21A* Bolt	DAS 38 9-89	Purchased	No			110	Each	82.0000	5	5		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST342				82					
				m132716				82					
D3230-041 *D3230-041* Basket Wedge Assembly	DAS 38 9-89	Manufactured	No			110	Each	0.0000	1	1		SEP 20 2015 DAS 6 9-89	
D5225-1 *D5225-1* Spacer	DAS 38 9-89	Manufactured	No			110	Each	5.0000	5	5		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST152				5					
				131539				5					
DSI 9053-011 *DSI 9053-011* Basket Hinge Kit	DAS 38 9-89	Manufactured	No			110	Each	1.0000	1	1		DAS 27 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				FG123				1					
				105169				1					

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Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Picklist Print

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Page 2

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Parent Item Name: Basket Volume Increase Modification

136894

DSI 9268-011

Start Date: 9/16/15

Required Date: 10/02/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

1,758.000

5

5

MS21042L 4

Locknut

DAS
38
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1474

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1294

DAS
27
9-89

DAS
27
9-89

NAS1149D0463J

Purchased

No

110

Each

2,631.000

5

5

NAS1149D0463J

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

1590

M129682

86

M130799

371

~~M12935~~

120

M132317

125

M132677

888

DAS
27
9-89

DAS
27
9-89

SEP 23 2015

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Shop Packet Print

Page 2

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OTHER : _____																																																													

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J

REF. CANADIAN STC: SH96-120

REF. FAA STC: SR00696NY

EASA STC: EASA.IM.R.S.01242

THE PURPOSE OF THE DSI 9268-011 BASKET MODIFICATION KIT IS TO INCREASE THE VOLUME OF THE D205-541-043/-044 BASKETS. NOTE THAT D205-541-041 BASKETS MUST BE CONVERTED INTO D205-541-043/-044 PER DSI 9226 BEFORE PERFORMING THIS MODIFICATION.

TO INSTALL THE DSI 9268-011 KIT:

- 1) FOR BASKETS WITH:
 - A) PIANO HINGES: INSTALL THE DSI 9053-011 HINGE CHANGE KIT AND SEPARATE LID FROM BASE.
OR
 - B) DSI 9053-011 HINGE CHANGE KIT ALREADY INSTALLED: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
OR
 - C) HINGE PLATES WELDED TO LID & BASE: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
- 2) ATTACH LID TO D3230-041 BASKET WEDGE ASSEMBLY. MOVE D2332-041 PROP ASSEMBLY FROM BASKET BASE TO WEDGE ASSEMBLY PER FIGURE 1.
- 3) LOCATE D3230-041 BASKET WEDGE ASSEMBLY COMPLETE WITH BASKET LID ON THE EXISTING BASKET BASE. ALIGN THE BACK EDGE AND TEMPORARILY CLAMP IN PLACE.
- 4) TRANSFER LOCATION OF 1/4" ATTACHMENT HOLES FROM WEDGE TO EXISTING BASE.
- 5) REMOVE WEDGE AND DRILL Ø0.266" HOLES THROUGH THE EXISTING BASE. DEBURR HOLES.
- 6) INSTALL WEDGE USING AN4-21A BOLTS, D5225-1 SPACERS, AN960JD416 WASHERS, AND MS21042L4 NUTS PROVIDED (5 PLACES TOTAL). NOTE THAT THE BOLTS IN SOME LOCATIONS MAY HAVE TO BE INSTALLED WITH THE NUTS ON TOP BECAUSE OF CLEARANCE ISSUES. CHECK FOR PROPER LATCHING OF THE EXISTING LID WITH THE WEDGE. SHIM AS REQUIRED TO ADJUST HEIGHT OF WEDGE ASSEMBLY TO ENSURE PROPER LATCHING.
- 7) ADJUST WEIGHT AND BALANCE AS FOLLOWS:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
DSI 9268-011	20 lb	± 63.13 in	± 1263 in-lb	132.25 in	2645 in-lb
BASKET MODIFICATION KIT	9 kg	± 1.60 m	± 14.4 m-kg	3.36 m	30 m-kg

DSI 9268-011 KIT PARTS LIST:

QTY	P/N	DESCRIPTION
X	DSI 9268-011	BASKET MODIFICATION KIT
1	D3230-041	BASKET WEDGE ASSEMBLY
5	D5225-1	SPACER
1	DSI 9053-011	HINGE CHANGE KIT
5	AN4-21A	BOLT
5	AN960JD416	WASHER
5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH96-120
ISSUE NO.: 3

D	ADD D5225-1 SPACER. AN4-21A BOLT WAS AN4-17A BOLT. REVISE INSTRUCTIONS TO IMPROVE FIT/FUNCTION REASON: NCR15-4557	DB	15.02.23
C	UPDATED TO CURRENT DWG STANDARDS; REVISED INSTALLATION STEP #1. CORRECTED TYPO (DSI 9053-011 WAS DSI 9052-011). REASON: REDESIGN OF D3230-041 (REF. NCR#09-010).	MB	09.02.02
B	CHANGE ORIENTATION OF WEDGE	CP	03.11.19
A	NEW ISSUE	CP	03.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	N/A	DSI 9268	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION KIT	NTS
DATE	15.02.23	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

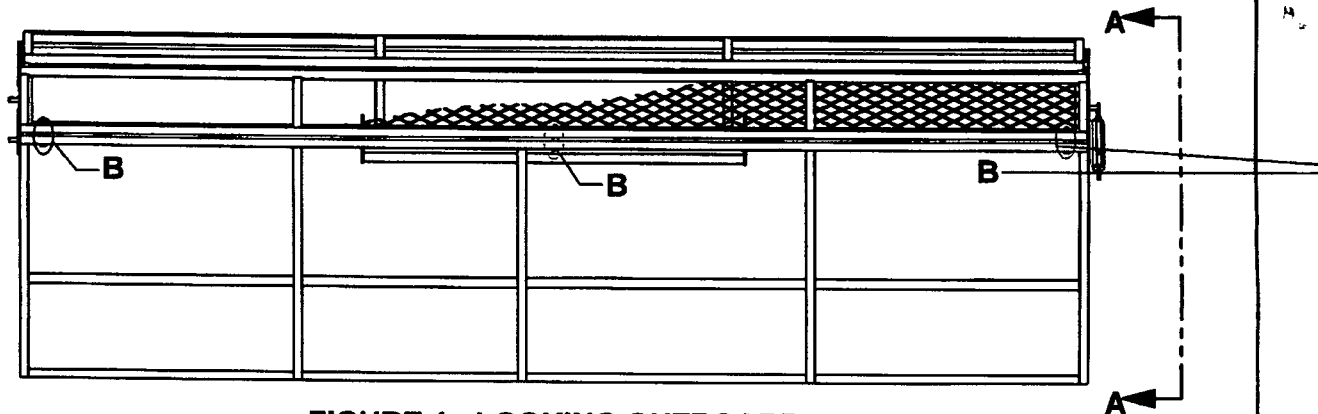
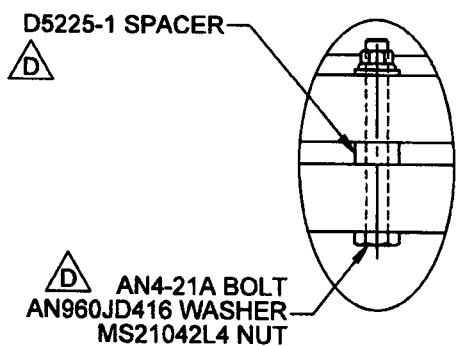
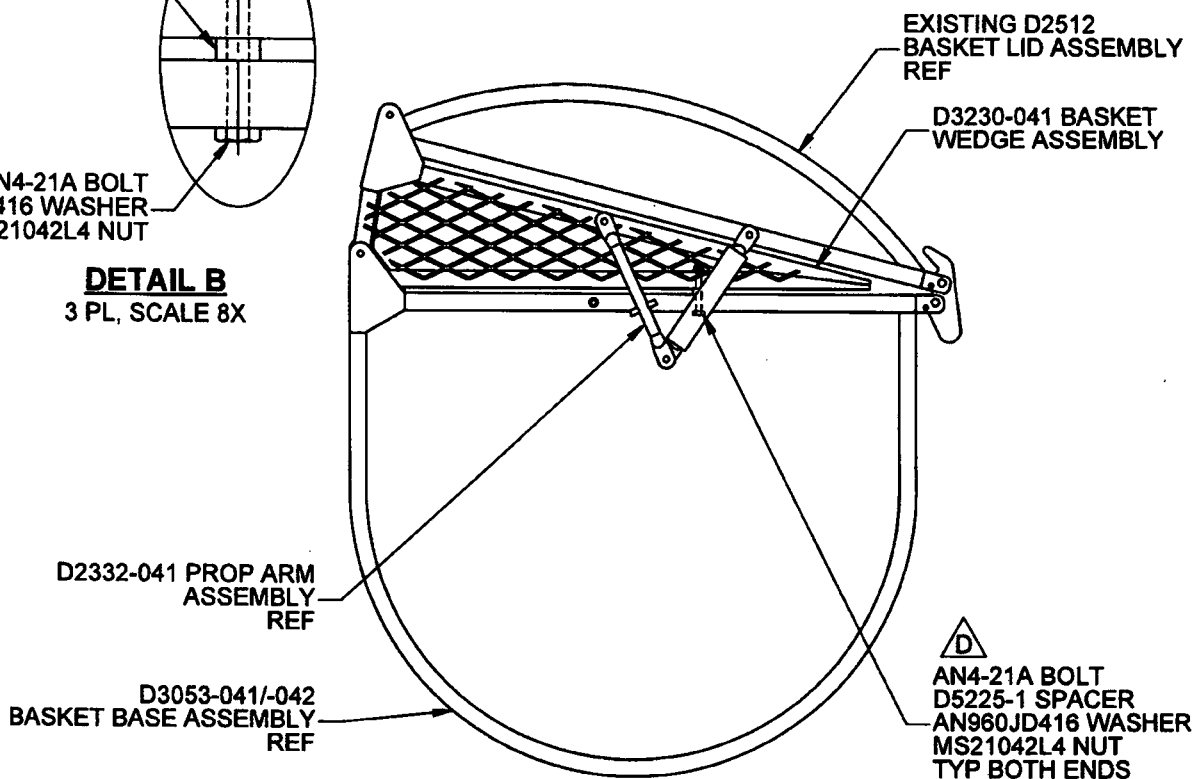


FIGURE 1 - LOOKING OUTBOARD
(MESH NOT SHOWN FOR CLARITY)



DETAIL B
3 PL, SCALE 8X



VIEW A-A
(MESH NOT SHOWN FOR CLARITY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH96-120
ISSUE NO.: 3

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	N/A	DSI 9268	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET MODIFICATION KIT	NTS
DATE	15.02.23	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J

REF. CANADIAN STC: SH96-120

REF. FAA STC: SR00696NY

EASA STC: EASA.IM.R.S.01242

THE PURPOSE OF THE DSI 9268-011 BASKET MODIFICATION KIT IS TO INCREASE THE VOLUME OF THE D205-541-043/-044 BASKETS. NOTE THAT D205-541-041 BASKETS MUST BE CONVERTED INTO D205-541-043/-044 PER DSI 9226 BEFORE PERFORMING THIS MODIFICATION.

TO INSTALL THE DSI 9268-011 KIT:

- 1) FOR BASKETS WITH:
 - A) PIANO HINGES: INSTALL THE DSI 9053-011 HINGE CHANGE KIT AND SEPARATE LID FROM BASE.
OR
 - B) DSI 9053-011 HINGE CHANGE KIT ALREADY INSTALLED: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
OR
 - C) HINGE PLATES WELDED TO LID & BASE: NO CHANGE IS REQUIRED. SEPARATE LID FROM BASE.
- 2) ATTACH LID TO D3230-041 BASKET WEDGE ASSEMBLY. MOVE D2332-041 PROP ASSEMBLY FROM BASKET BASE TO WEDGE ASSEMBLY PER FIGURE 1.
- D 3) LOCATE D3230-041 BASKET WEDGE ASSEMBLY COMPLETE WITH BASKET LID ON THE EXISTING BASKET BASE. ALIGN THE BACK EDGE AND TEMPORARILY CLAMP IN PLACE.
- 4) TRANSFER LOCATION OF 1/4" ATTACHMENT HOLES FROM WEDGE TO EXISTING BASE.
- 5) REMOVE WEDGE AND DRILL Ø0.266" HOLES THROUGH THE EXISTING BASE. DEBURR HOLES.
- D 6) INSTALL WEDGE USING AN4-21A BOLTS, D5225-1 SPACERS, AN960JD416 WASHERS, AND MS21042L4 NUTS PROVIDED (5 PLACES TOTAL). NOTE THAT THE BOLTS IN SOME LOCATIONS MAY HAVE TO BE INSTALLED WITH THE NUTS ON TOP BECAUSE OF CLEARANCE ISSUES. CHECK FOR PROPER LATCHING OF THE EXISTING LID WITH THE WEDGE. SHIM AS REQUIRED TO ADJUST HEIGHT OF WEDGE ASSEMBLY TO ENSURE PROPER LATCHING.
- 7) ADJUST WEIGHT AND BALANCE AS FOLLOWS:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
DSI 9268-011	20 lb	± 63.13 in	± 1263 in-lb	132.25 in	2645 in-lb
BASKET MODIFICATION KIT	9 kg	± 1.60 m	± 14.4 m-kb	3.36 m	30 m-kb

DSI 9268-011 KIT PARTS LIST:

QTY -011	P/N	DESCRIPTION
X	DSI 9268-011	BASKET MODIFICATION KIT
D 1	D3230-041	BASKET WEDGE ASSEMBLY
5	D5225-1	SPACER
D 1	DSI 9053-011	HINGE CHANGE KIT
5	AN4-21A	BOLT
5	AN960JD416	WASHER
5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 15.02.23
CERT. NO.: SH96-120
ISSUE NO.: 3

D	ADD D5225-1 SPACER, AN4-21A BOLT WAS AN4-17A BOLT, REVISE INSTRUCTIONS TO IMPROVE FIT/FUNCTION REASON: NCR15-4557	DB	15.02.23
C	UPDATED TO CURRENT DWG STANDARDS; REVISED INSTALLATION STEP #1. CORRECTED TYPO (DSI 9053-011 WAS DSI 9052-011). REASON: REDESIGN OF D3230-041 (REF. NCR#09-010).	MB	09.02.02
B	CHANGE ORIENTATION OF WEDGE	CP	03.11.19
A	NEW ISSUE	CP	03.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9268 TITLE BASKET MODIFICATION KIT REV. D SHEET 1 OF 2 SCALE NTS	
DRAWN	DB		
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	15.02.23		

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